

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017846**Date Inspected:** 02-Oct-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Zhu Zhong Hai**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Orthotropic Box Girder (OBG)**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Manoj Prabhune was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

This QA Inspector randomly observed the following work in progress:

OBG # TRIAL ASSEMBLY YARD

Segment # 10BE ~ 10CE

Repair Welding.

This QA inspector observed, ZPMC qualified welding personnel identified as 044515 perform Shielded Metal Arc Welding (SMAW), weld joint identified as OBE10C-003; The Critical Welding Repair Report (CWRR) was B-CWR1968. ZPMC QC is identified as Mr. Wang Li Yang. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-SMAW-1G (1F) FCM-Repair-1. See the attached Photo.

CB#14

This QA inspector observed, ZPMC qualified welding personnel identified as 040759 perform Flux Core Arc Welding (FCAW), weld joint identified as CA202A-014-006; ZPMC CWI is identified as Mr. Li Yang. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2232-TC-U4b-F.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

Segment # 10CE

This QA inspector observed, ZPMC qualified welding personnel identified as 040458 perform Flux Core Arc Welding (FCAW), weld joint identified as SP633-001-045; ZPMC CWI is identified as Mr. Li Yang. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2132.

Segment # 11BE

This QA inspector observed, ZPMC qualified welding personnel identified as 040609 perform Shielded Metal Arc Welding (SMAW), weld joint identified as SEG068A-028; ZPMC QC is identified as Mr. Wang Li Yang. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-P-2214-TC-U4b-FCM-1.

Segment # 11AE ~ 11BE

This QA inspector observed, ZPMC qualified welding personnel identified as 067752 perform Shielded Metal Arc Welding (SMAW), weld joint identified as CA082-001; ZPMC QC is identified as Mr. Wang Li Yang. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-P-2214-TC-U4b-FCM-1.

Segment #10BW

Repair Welding.

This QA inspector observed, ZPMC qualified welding personnel identified as 040656 perform Shielded Metal Arc Welding (SMAW), weld joint identified as OBW10L-008; The Welding Repair Report (WRR) was B-WR15468. ZPMC QC is identified as Mr. Zhou Peng. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-SMAW-4G (4F) FCM-Repair-1.

Segment #10BW

Repair Welding.

This QA inspector observed, ZPMC qualified welding personnel identified as 046709 perform Shielded Metal Arc Welding (SMAW), weld joint identified as OBW10L-009; The Welding Repair Report (WRR) was B-WR15477. ZPMC QC is identified as Mr. Zhou Peng. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-SMAW-4G (4F) FCM-Repair-1

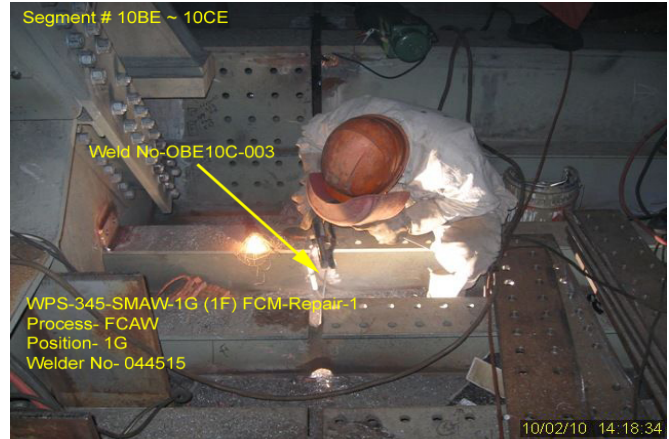
Segment # 10CW

During random visual inspection this Caltrans Quality Assurance (QA) inspector observed that ZPMC personnel had performed heat straightening on various locations on T-Rib Hold Back Weld area Side plate in OBG segment 10CW at panel point 94. ZPMC QC is identified as Mr. Wang Zhu the variables recorded by QC appeared to comply with the Heat Straightening Report (HSR) was HSR1 (B) 9478. See the attached Photo.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)



Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang phone: 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Prabhune,Manoj	Quality Assurance Inspector
Reviewed By:	Patterson,Rodney	QA Reviewer
